

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000154**Date Inspected:** 20-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

Witness: **Procedure Qualification Record**
Welding **NDT**

Welder Qualification **Fracture Critical**
Mechanical Testing, describe:

Index Lot #: B49-014-07**Witness Lot #:****Bridge No:** 34-0006**Component:** Bid: 52, 55 Tower & Girder**Welder:** Zhang Xing Jin**ID #:** NA**Joint Description:** B-U2-S**WPS ID #:** PWPS-B-T-2221-F-4 **N/A****Base Metal:** A709-50F-2**PQR ID #:** HP200746-3 **N/A****Thickness:** 26mm**Process:** SAW **N/A****Electrode Spec/Class:** A5.23/ENi5**Positions:** 1G **N/A****Backing Material:** A709-50F-2**CWI:** Huang Wei **N/A****Average Amps:** 599.2**AWS Code:** D1.5 **N/A****Average Volts:** 30.8**Applicable Sec:** 5.13 **N/A****Travel Speed:** 450mm/min**Heat Input:** 2.46 kJ/mm **N/A****Preheat:** 80 degrees Celsius**N/A****Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector was present as requested to witness procedure qualification test of complete joint penetration groove weld in the flat position. The procedure qualification record (PQR) test is identified as HP200746-3. The welding consumable electrode is identified as 4.8mm diameter, specification AWS A5.23, classification ENi5 (LA-85) and MIL800-HPN flux. The welding was performed in accordance with AWS D1.5 and appeared to comply with the contract documents. The completed weld test was visually inspected by ZPMC Quality Assurance Inspector, Mr. Huang Wei and accepted for conformance per contract documents.

Summary of Conversations:

At 0900 hours. ZPMC Quality Assurance Inspector, Mr. Hu Gang met with Caltrans QA and stated that ZPMC would be performing procedure qualification testing at ZPMC testing facility at 0930 hours, PQR HP200746-3. is in general conformance with the contract requirements.

Observed welding,testing or results:

WELDING WITNESS REPORT

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is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	McClary, David	QA Reviewer
